

Date: Tuesday, 13/05/2008 9:30:16 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	39233		
Estimate Number :	12731		
P.O. Number :		Part Number :	D353535
This Issue :	13/05/2008	Drawing Number :	D3535 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	38760	Material :	
Written By :		Due Date :	30/05/2008
Checked & Approved By :	JLD 08.5.13	Qty:	20 Um: Each
Comment :	Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.8423 sf(s)/Unit Total : 16.8462 sf(s)
 304/316 .040 Sheet
 (M304S20GA)
 Batch: ~~108118~~ IB 8-5-27

108118 X 2 + 6 6.8
 107909 X 3 + 2 4.5

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3535
 Dwg Rev: B
 Prog Rev: B

IB 8-5-27

2-Deburr if necessary

IB 8-5-27

(13)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 8-5-27

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

508/05/27 (13)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary
 2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.
 3-Identify as D3535-35.

508/05/27

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 13/05/2008 9:30:16 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 39233

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/27 (13)

7.0

POWDER COATING

POWDER COATING



m105642



(13x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

7:30

OVEN TEMPERATURE:

320

FINISH TIME:

8:00

M. 08/05/28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-28 (13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-17

08/05/28

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/29

Job Completion



mf 08-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39233
Description: Wearshoe		Part Number: D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.002	X			
1.885	+/-0.010	1.887	X			
6.00	+/-0.030	6.00	X			
6.75	+/-0.030	6.75	X			
Ø0.188	+0.005/-0.001	.190	X			
23.250	+/-0.010	23.250	X			
19.750	+/-0.010	19.750	X			
17.750	+/-0.010	17.750	X			
14.250	+/-0.010	14.250	X			
9.500	+/-0.010	9.500	X			
4.750	+/-0.010	4.750	X			
0.300	+/-0.010	.302	X			
0.300	+/-0.010	.304	X			
0.038	+/-0.010	.034	X			

Measured by: AB
Date: 8-5-07

Audited by: S
Date: 09/05/27

Prototype Approval:	N/A
Date:	N/A

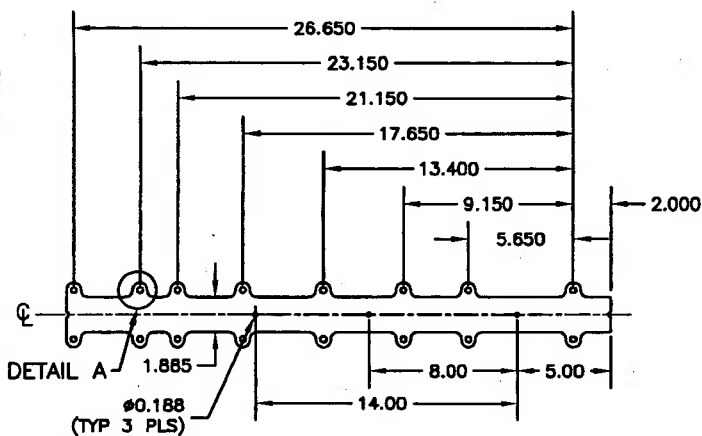
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

DART

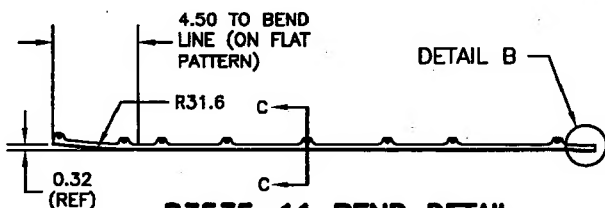
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07.04.24

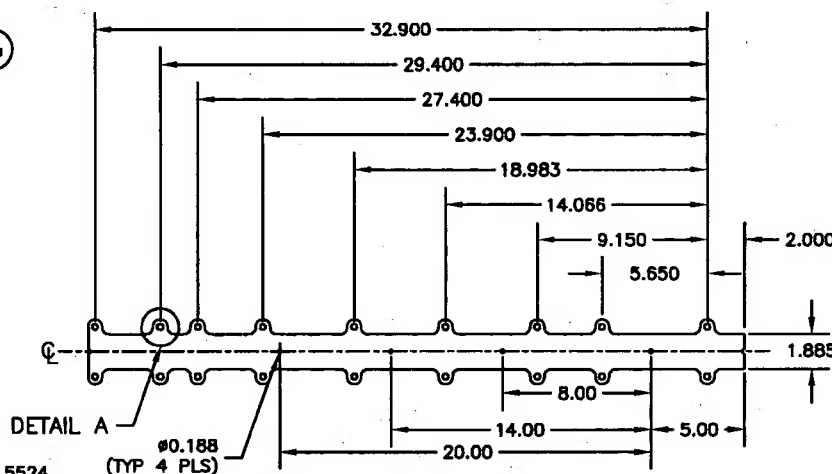
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3535	REV. B
DATE	07.04.17	TITLE	WEARSHOE	SHEET 1 OF 7		
A	06.10.25	NEW ISSUE				
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC				



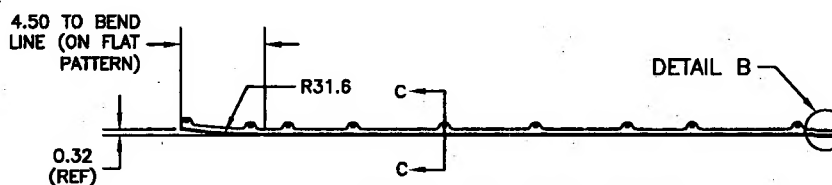
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

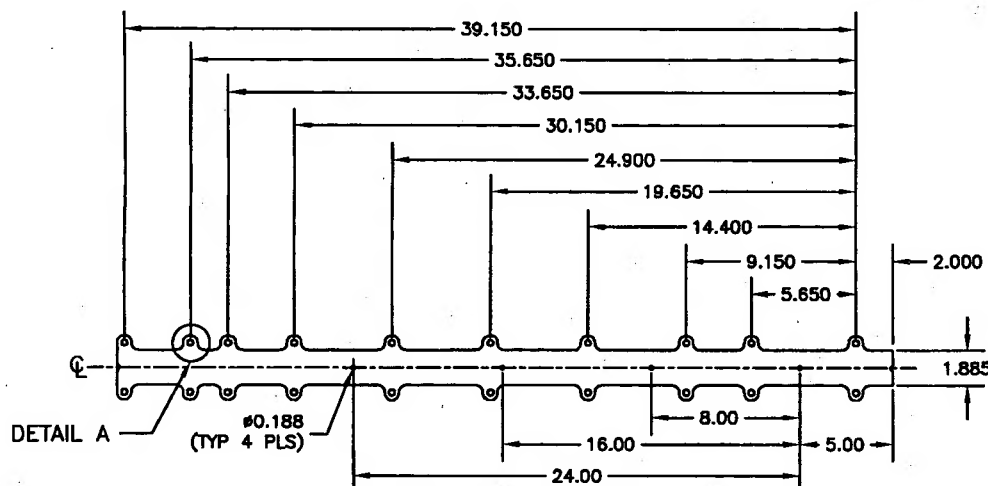
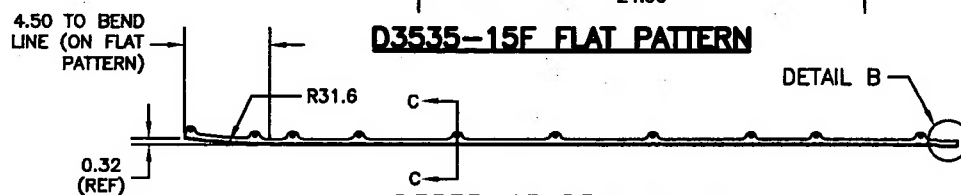
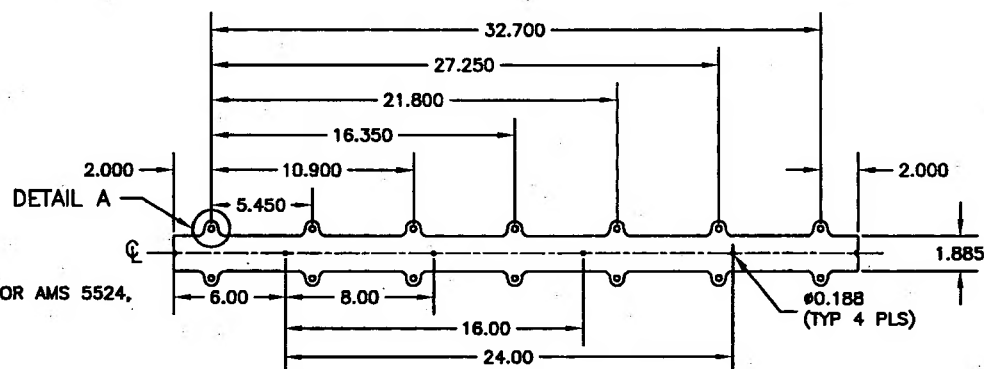
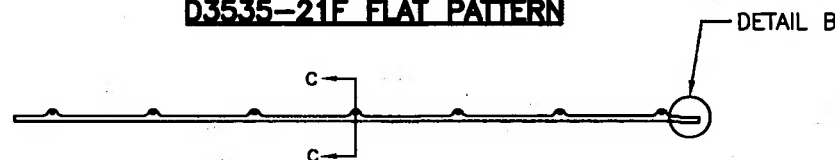
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WORK ORDER
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
		SCALE	1:10	

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

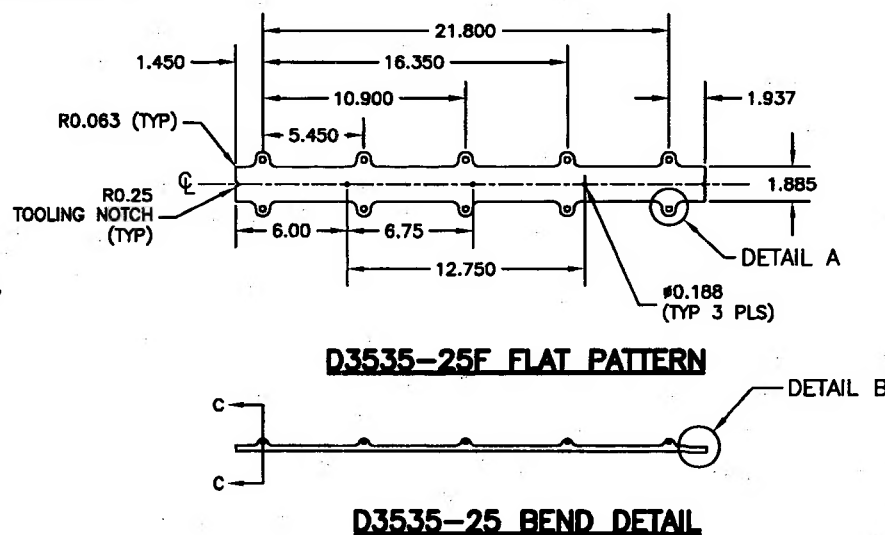
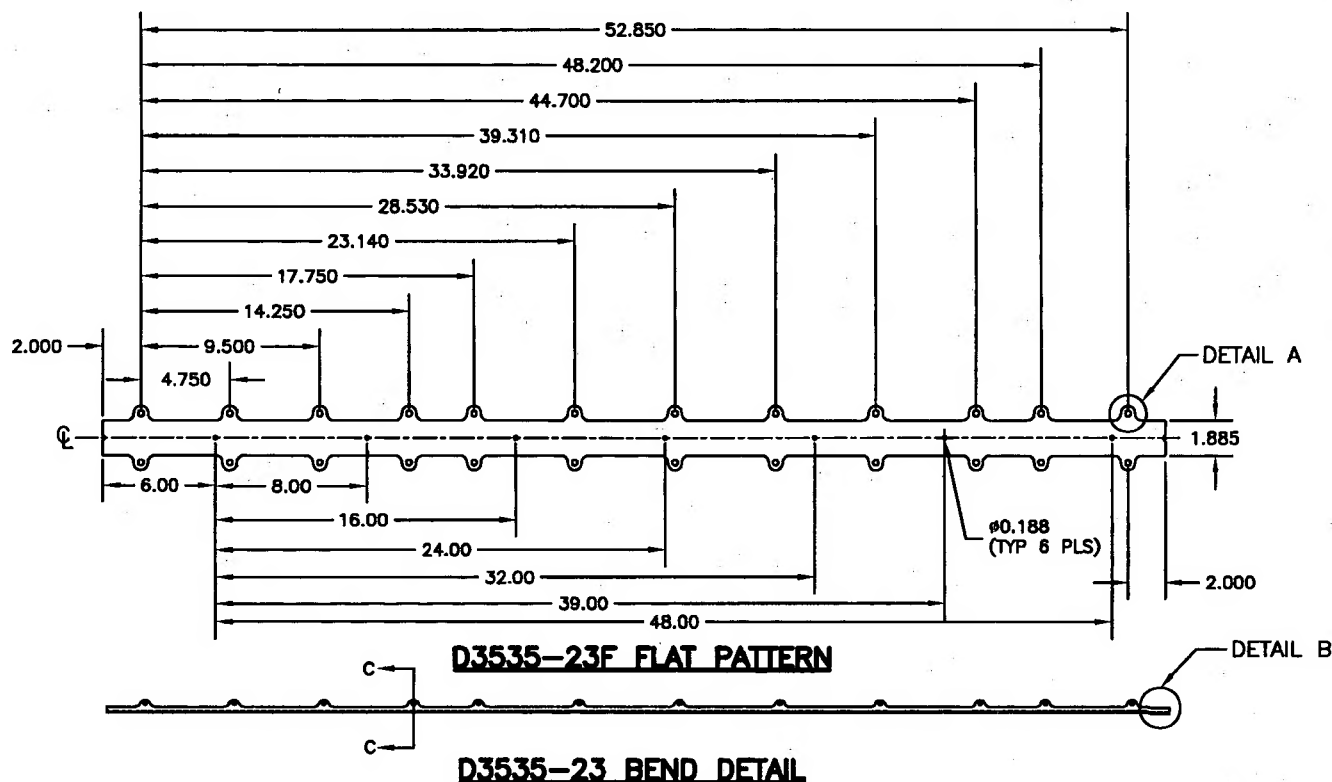
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DATE	07.04.17	TITLE	D3535	REV. B
			WEARSHOE	SHEET 3 OF 7
		SCALE	1:10	



NOTES

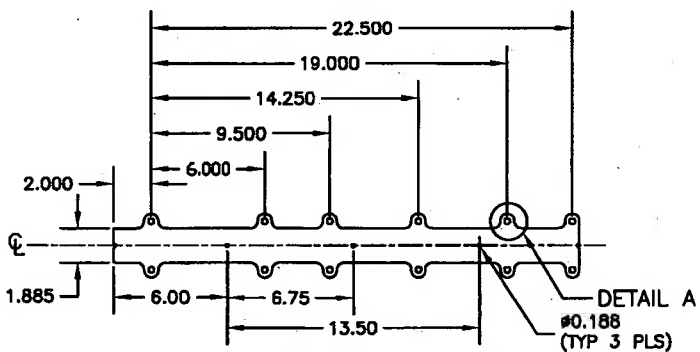
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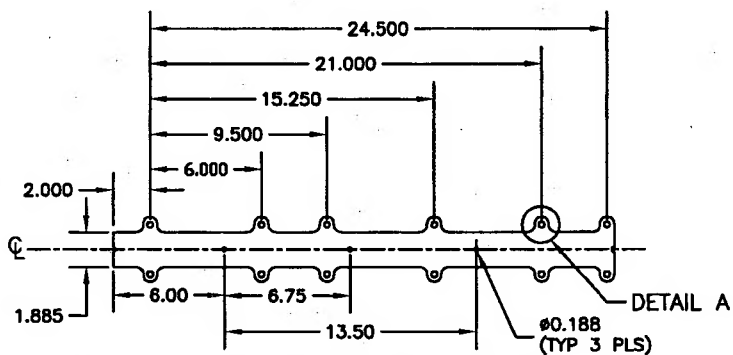


D3535-31F FLAT PATTERN



D3535-31 BEND DETAIL

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D3535-33F FLAT PATTERN



D3535-33 BEND DETAIL

NOTES

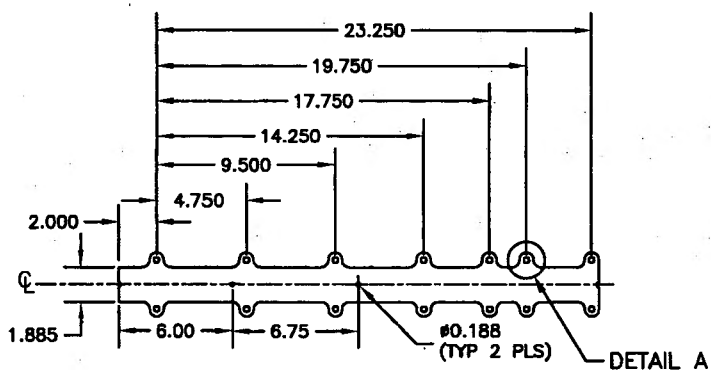
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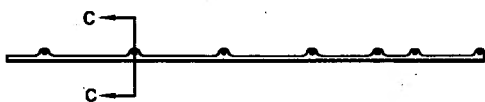
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DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



D3535-35F FLAT PATTERN

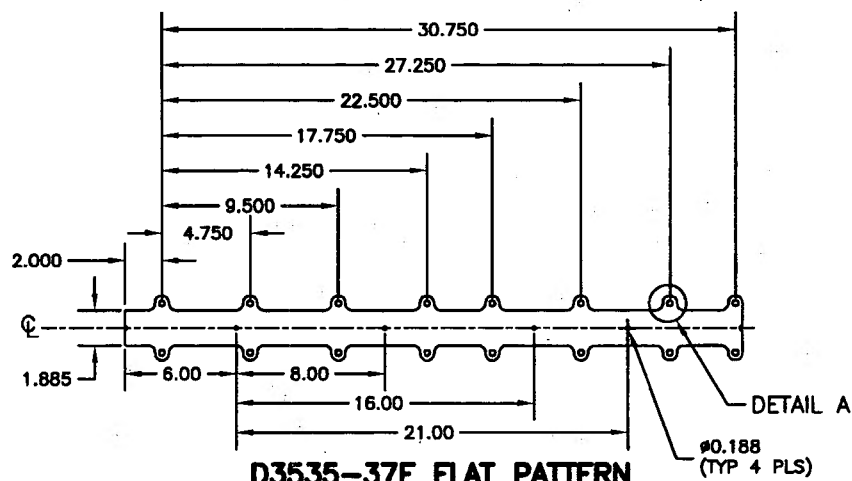


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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-37F FLAT PATTERN

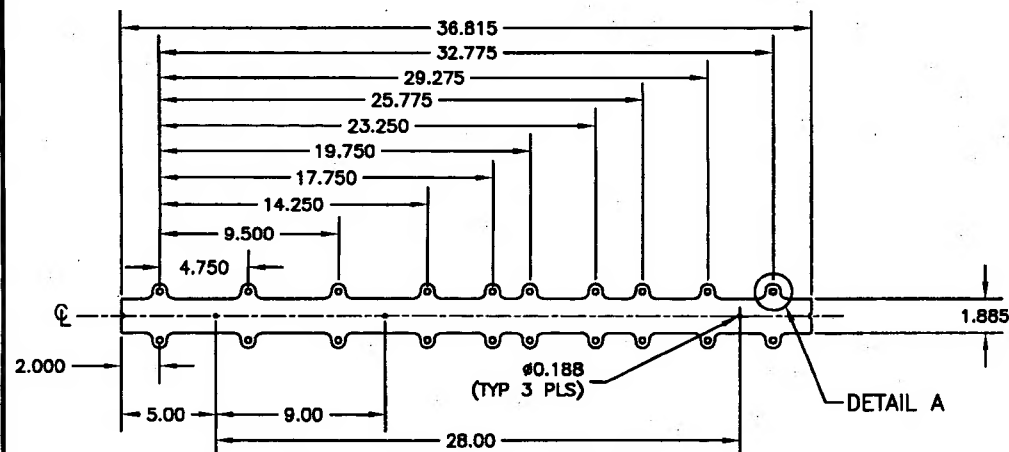
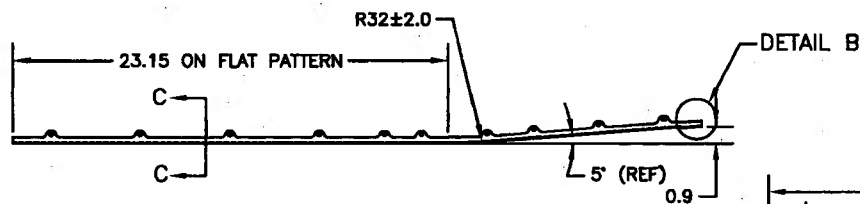


D3535-37 BEND DETAIL

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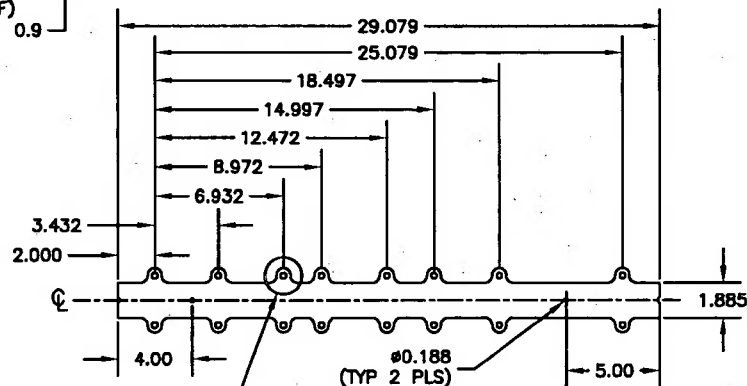
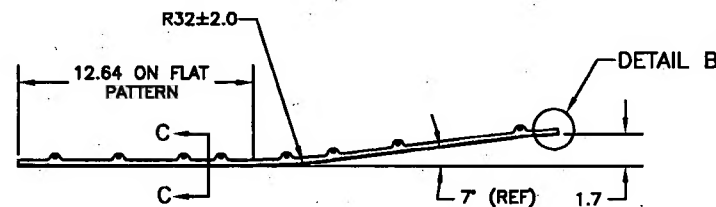
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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL**

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL**

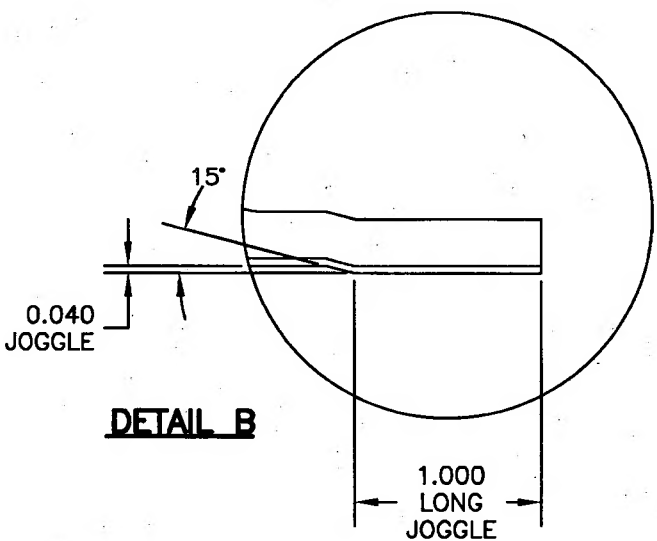
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DATE	07.04.17	TITLE	D3535	REVISION	REV. B
			WEARSHOE	SHEET 6 OF 7	
				SCALE	1:10

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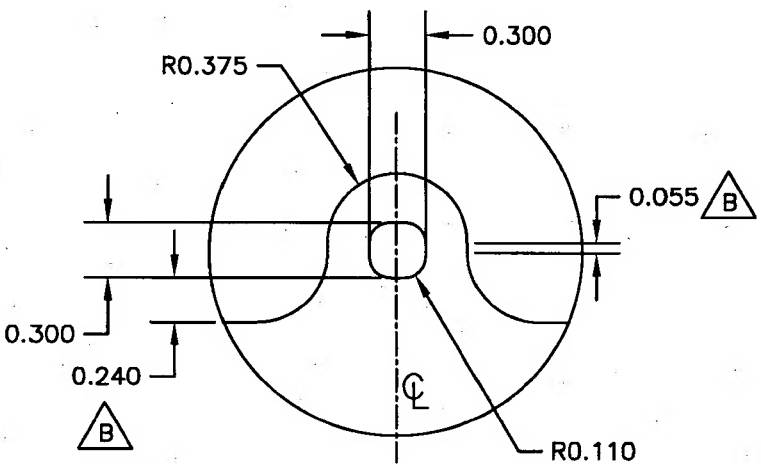
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
				SCALE 1:1

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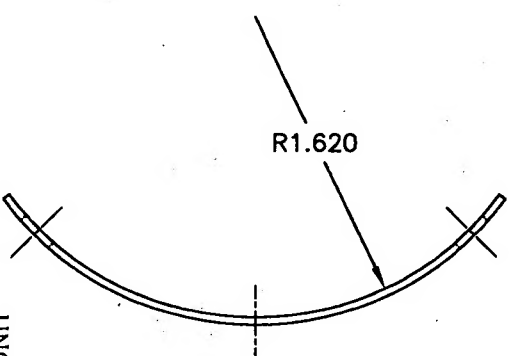
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DETAIL B



DETAIL A



SECTION C-C

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